



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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006040

D350-748-203
Job Sheet 181669



Part No: D350-748-203

Job Qty: 1 ea

Part Name: AS350 / AS355 Stainless Steel Aft Crosstube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/3/18

Job Tracking No:

Due Date: 8/24/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D350-748-243 REV:A IPP REV:A 15.03.23 NEW ISSUE DD VERF, JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea	8/24/18	8/24/18	0.00	0.00	Start Up Crosstubes-1		DPZ
110	CNC Bend Crosstubes	1 pcs	8/24/18	8/24/18	5.40	2.44	CNC Bend Crosstube		DPZ
120	Crosstubes	1 pcs	8/24/18	8/24/18	0.00	2.19	Crosstubes-2		DPZ
127	QC	1 pcs	8/24/18	8/24/18	0.00	0.00	QC15		DAS
128	Crosstubes	1 pcs	8/24/18	8/24/18	0.00	1.98	Crosstubes-2		38
130	Crosstubes	1 pcs	8/24/18	8/24/18	0.00	2.89	Crosstubes-2		SP 2018-04
140	QC	1 pcs	8/24/18	8/24/18	0.00	0.00	QC6		GP 2018-10-04
174	Outsource	1 pcs	8/24/18	8/24/18			SKY002-VC	P004/267	38
176	Packaging	1 pcs	8/24/18	8/24/18	0.00	0.00	Packaging2		9-00 OCT 09 2018
178	QC	1 pcs	8/24/18	8/24/18	0.00	0.00	QC5		38
180	SprayPaint	1 pcs	8/24/18	8/24/18	0.00	1.07	Spray Paint		9-00 OCT 12 2018
190	QC	1 pcs	8/24/18	8/24/18	0.00	0.00	QC14		18-10-13
200	Crosstubes	1 pcs	8/24/18	8/24/18	0.00	2.89	Crosstubes-2		21 18-10-16
210	QC	1 pcs	8/24/18	8/24/18	0.00	0.00	QC5		9-00 OCT 23 2018
220	Packaging	1 pcs	8/24/18	8/24/18	0.00	0.00	Packaging1-3		62 9-00
230	QC	1 pcs	8/24/18	8/24/18	0.00	0.00	QC4		BB 9-00 OCT 29 2018
240	Packaging	1 pcs	8/24/18	8/24/18	0.00	0.00	Packaging3-1		BB 9-00 OCT 29 2018
245	DC	1 pcs	8/24/18	8/24/18	0.00	0.00	DC		21 9-00 OCT 30 2018
250	QC21-FG	1 Ea	8/24/18	8/24/18	0.00	0.00	QC21		9-00 DAS OCT 30 2018

Part Op 110 - Bend tube as per Dwg D350-748-243 using CNC bender program D350A and Folio FT

Descriptions: BEND .225" PER SIDE*****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****

120 - ****VERIFY CROSSTUBE DIMENSIONS AS PER DWG****

127 - ****MARK CUT LINES****

128 - CUT TUBE AT HEIGHT ON FAI SHEET VERF HEIGHT 31.375 BY QC 15 LEVEL INSPECTOR

130 - 1- Drill Tube as per Dwg D350-748-243 Using DT8876 Drill Jigs, set-up drill table as per QSI 010. 2-Deburr 3- Engrave Part # and Batch # as per Dwg D350-748-243 4- Remove all marks from tube within limits of D350-748-243

174 - ISSUE P/O TO SKY SERVICE:

180 - ***VERIFY BY BATCH # TO MATCH W/O ***MASK SCRIBE B# & P# AND VERIFY*** 1. Apply Axalta 13205S Cleaner inside and outside crosstube per QSI 005 4.1.4 BATCH: 138949 2.

Axalta 230S Metalok inside and outside crosstube per QSI 005 4.1.4 BATCH: 138021 3. Prime inside and outside crosstube per QSI 005 4.2 BATCH: 138377 4. Paint outside of crosstube per QSI 005 4.2 BATCH: 138956

190 - Then, Wrap in plastic bag to protect from scratches ***VERIFY BY BATCH # TO MATCH W/O

200 - INSTALL GROUND WIRE INSERT, THEN INSERT SCREW AND WASHER ***LIMIT AIR PRESSURE TO 50 PSI WHEN INSTALLING AETC-1032 INSERT AND ONLY EXPAND INSERT ONCE*** 1-Abrade mating surfaces of support

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2-Install supports with Proseal 890 per D350-748-243 and QSI 015 A/R Proseal 890 Batch: 5016394 EXP: 3/19 3-Install supports clamps Using Dt8876 as per Dwg D350-748-243, Torque to 60-80 IN-LBS. PROSEAL CURE TIME 72 HOURS: Start: _____ Finish: _____

210 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
 ***VERIFY BY _____ BATCH # TO MATCH W/O _____

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

240 - Identify and pack for shipping as per PPPD350-748-203 Location: _____ PPP Rev: _____

245 - Photocopy bluefile & type labels per PPPD350-748-203 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-748-243TRN	Crosstube Installation, High Aft	1 Ea (1 ea)	90-Start up Operation	5055291
AETC-1032	Insert	1 Ea (1 ea)	200-Crosstubes	
D3502-1	Support	2 Ea (2 ea)	200-Crosstubes	
D5123-7	Clamp Cushion	2 Ea (2 ea)	200-Crosstubes	
MS21920-20	Clamp	2 Ea (2 ea)	200-Crosstubes	
NAS1149C0363R	Washer	1 Ea (1 ea)	200-Crosstubes	
MS51958-63	Screw	1 pcs (1 ea)	200-Crosstubes	
AN4-41A	Bolt	8 Ea (8 ea)	220-Packaging	5006292
AN4-6A	Bolt	16 Ea (16 ea)	220-Packaging	5089458
AN5-32A	Bolt	4 Ea (4 ea)	220-Packaging	5058983-1
D3500-1	Saddle	4 Ea (4 ea)	220-Packaging	5088731
D3501-1	Bushing	16 Ea (16 ea)	220-Packaging	5094369
MS21042L4	Nut	24 Ea (24 ea)	220-Packaging	5094592
MS21042L5	Nut	4 Ea (4 ea)	220-Packaging	5093592
MS51958-63	Screw	1 pcs (1 ea)	220-Packaging	FM134962
NAS1149D0463J	Washer	32 Ea (32 ea)	220-Packaging	5092780
NAS1149D0563J	Washer	8 Ea (8 ea)	220-Packaging	5050053

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D350-748-243TRN	1	2	0
200-Crosstubes	AETC-1032 FM137335	①	235	0
	D3502-1 FM163847	②	78	0
	D5123-7 163264	②	345	0
	MS21920-20 5034464 5073265	②	140	0
	MS51958-63 FM134962	①	66	0
	NAS1149C0363R 5054113	①	249	0
220-Packaging	AN4-41A	8	654	0
	AN4-6A	16	1,474	0
	AN5-32A	4	365	0
	D3500-1	4	113	0
	D3501-1	16	543	0
	MS21042L4	24	6,198	0
	MS21042L5	4	1,112	0
	MS51958-63	1	66	0
	NAS1149D0463J	32	10,335	0
	NAS1149D0563J	8	2,086	0

Part Specifications

Specifications could



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 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S115417



Part: D350-748-203

Job No: 181669

Serial No/Batch: S115417

Revision: A

Inspector:

Exp Date:

Instructions: TC STC SH06-27 Issue 2, FAA-ETC SR02359NY 11/03/04, EASA S

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

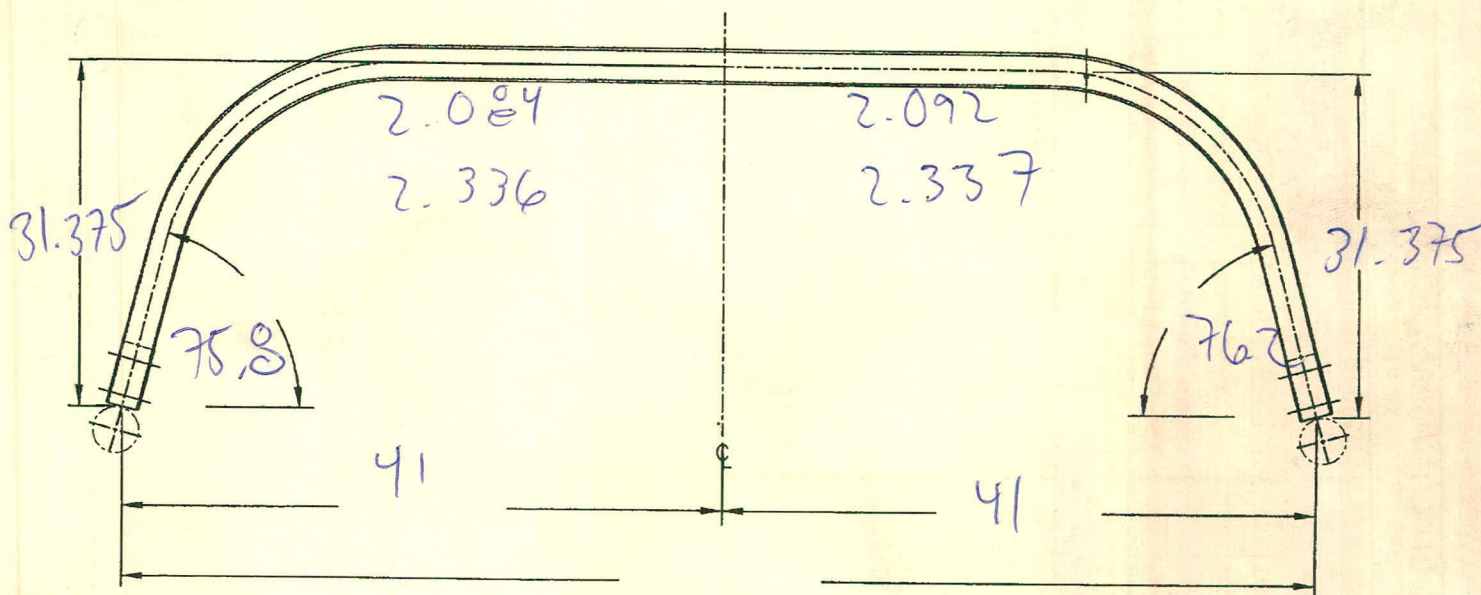
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DART AEROSPACE LTD		Work Order: 18/669
Description: Crosstube High Aft, SS (AS350/355)		Part Number: D350-748-203
Inspection Dwg: D350-748-243	Rev: A	Page 1 of 1

Required Dimension	Min	Max
Height	31.10	31.60
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06
Bending Passes	7	--
Crushing	--	8%
Twist	--	0.38



	Side A	Side B
Bending Passes	32	32
Crushing	5.7%	5.5%
Comments		

QC15 Inspection	2D
Date	18-10-02

Rev	Date	Change	Revised by	Approved
A	15.09.09	New Issue	KJ	

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OTHER : _____					

Item	Qty -243	Part Number	Description
1	X	D350-748-243	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
2	1	D6021-125	CROSSTUBE
3	2	D3502-1	SUPPORT
4	2	D5123-7	CLAMP CUSHION
5	1	AETC-1032	INSERT
6	2	MS21920-20 OR MS21920-21/-22	CLAMP (PER DART SPEC. M-MS21920-20/-21/-22)
7	1	NAS1149C0363R	WASHER (OR AN960C10)
8	1	NAS1635-3-8	SCREW (OR MS51958-63)
9	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6021-125
FINISHED LENGTH AFTER TURNING = 124.70±0.06 (AFTER BENDING/TRIMMING = 122.70 REF)
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCE: PER DART QSI 018 UNLESS OTHERWISE NOTED.
WALL THICKNESS ECCENTRICITY PER DART QSI 038 7.2
MIN. ALLOWABLE WALL IS -0.020 FROM NOMINAL
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-243" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 29.85 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.290 HOLE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.

TURNING

- 10) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.

BENDING

- 11) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES PER SIDE. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D. ON TOP HALF OF BEND, AND 8% ON BOTTOM HALF OF BEND.
- 12) MAX AMPLITUDE OF RIBBLING ALONG BENT PORTION OF THE TUBE IS 0.030 (ZN A1-3)
- 13) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.38 (ZN C1-3).

ASSEMBLY

- 14) TO INSTALL D3502-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.02" TO 0.05" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 60 TO 80 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 181669 MWS

18-08-03

DEO ATTACHED

RELEASED

2015 MAR 18

RELEASED

2015 MAR 18

UNDER REVIEW

15/4/15
LRF 15/3/15
OK
9/16/15

A	NEW ISSUE	CP	15.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D350-748-243	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



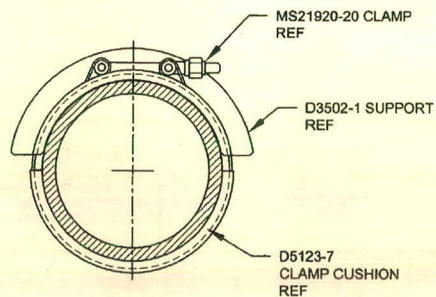
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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**D350-748-243
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 6X

INSTALL THIS SIDE ONLY, AFTER FINISH:
AETC-1032 INSERT
NAS1149C0363R WASHER
NAS1635-3-8 SCREW

14 15
D3502-1 SUPPORT
MS21920-20 CLAMP (OR -21/-22)
D5123-7 RUBBER CUSHION
2 PL

D350-748-243
BENT TUBE

DEO ATTACHED

RELEASED

2015 MAR 18

UNDER REVIEW

15/4/22 6K 9/16/25

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	7/11/22	D350-748-243	SHEET 2 OF 4
APPROVED	7/11/22	TITLE	SCALE
DE APPR.	7/11/22	CROSSTUBE (AS 350/355 HI AFT)	NTS
DATE	15.01.21	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Misidentified	☐	Past Due	☐								

DQA: _____ Date: _____



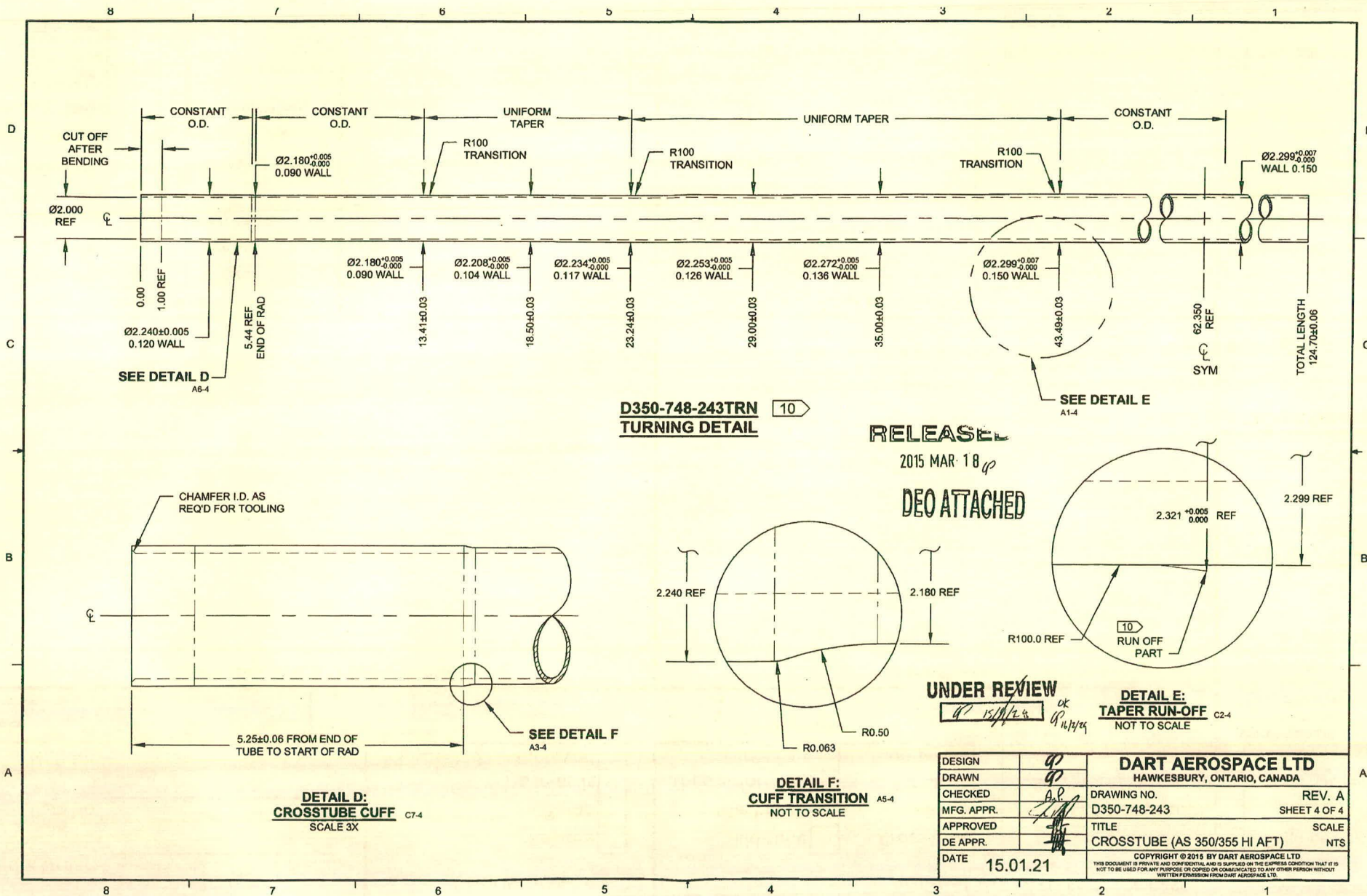
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Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																				
Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																				
Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER :																																																																							

DRAWING NO. D350-748-243	TITLE CROSSTUBE	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D350-748-243-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 15.11.18	DATE 15.11.18	DATE 16.02.19	DATE FEB 19 2016		DATE 2016.02.19		

AMEND NOTE 2 (SHEET 1) AS FOLLOWS:

- 2) FINISH: PREPARE SURFACE PER DART QSI 005 4.1.4
 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
 PAINT OUTSIDE PER DART QSI 005 4.2
 OR
 POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

RELEASED
 2016-02-26
EN 16-534 *[Signature]*

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 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041267**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041267
PO Date: 10/5/18
Due Date: 10/9/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

E-MAILED
OCT 09 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181664	D350-748-103	AS350 / AS355 Stainless Steel Fwd Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
	181667			Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
2	181669	D350-748-203	AS350 / AS355 Stainless Steel Aft Crosstube : TC STC SH06-27 Issue 2, FAA STC SR02359NY 11/03/04, EASA STC EASA.10016903 Revision 2 10/09/03, BRAZIL 2009S04-04 09/04/06 ISSUE P/O TO SKY SERVICE:	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
	181670			Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
3	182672	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86

DAS
38
9-89

2A1
GP
100



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041267**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	182673		OCT 0 9 2018	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Sub Total:							2	0	2		\$285.71
4	182675	D206-667-103	Fwd Crosstube - High 206L / L1 / L3 / L4 : TC STC SH01-5 Issue 3, FAA STC SR01304NY 05/12/15, JCAB JAPAN STC-32-OSA 02/02/28, EASA STC EASA.IM.R.S.01179 06/07/03, BRAZIL 2009S08-16 09/08/25, BRAZIL 2009S08-17 09/08/25 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	-	10/8/18	1 pcs	0 pcs	1 pcs	\$142.85714/pcs	\$142.86
Grand Total:											\$1,000.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/9/18 11:03 AM dart.lavoie.chantal

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37683	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041267 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	

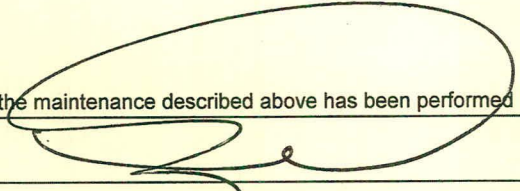
Task: UNSCHEDULED	Sequence: 1
--------------------------	-------------

Work Required:**CARRY OUT NDT ON:**

- ✓ 3 FWD CROSSTUBES , P/N# D206-667-103 , J/S# 182672 , 182673 , 182675 ✓
✓ 2 STAINLESS STEEL FWD CROSSTUBES , P/N# D350-748-103 , J/S# 181664 , 181667 ✓
✓ 2 STAINLESS STEEL AFT CROSSTUBES , P/N# D350-748-203 , J/S# 181669 , 181670 ✓

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417 REV. 16 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						OCT 05 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: OCT 05 2018
Name: RAFIK MELIKIAN		

4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/AFT	WEIGHT	STA	MOMENT
D350-748-101 D350-748-103	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201 D350-748-203	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

5.0 PARTS LIST

Qty -101	Qty -103	Qty -201	Qty -203	Part Number	Description
X				D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X			D350-748-103	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD (SS)
		X		D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
			X	D350-748-203	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT (SS)
1				D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1			D350-748-143	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD (SS)
		1		D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
			1	D350-748-243	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT (SS)
*2	*2	*2	*2	D3502-1	SUPPORT
*2	*2	*2	*2	D5123-7	CLAMP CUSHION
*1		*1		AELS-1032-225	INSERT
	*1		*1	AETC-1032	INSERT
*2	*2	*2	*2	MS21920-20	CLAMP (OR MS21920-21/-22)
*1		*1		MS27039-1-10	SCREW
	*1		*1	NAS1685-3-8	SCREW (OR MS51958-63)
*1		*1		NAS1149D0363J	WASHER (OR AN960JD10)
	*1		*1	NAS1149C0363R	WASHER (OR AN960C10)
4	4	4	4	D3500-1	SADDLE
16	16	16	16	D3501-1	BUSHING
16	16	16	16	AN4-6A	BOLT
8	8	8	8	AN4-41A	BOLT
4	4	4	4	AN5-32A	BOLT
32	32	32	32	NAS1149D0463J	WASHER (OR AN960JD416)
8	8	8	8	NAS1149D0563J	WASHER (OR AN960JD516)
24	24	24	24	MS21042L4	NUT (OR MS21042-4)
4	4	4	4	MS21042L5	NUT (OR MS21042-5)

* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/-143/-241/-243 ASSEMBLIES ABOVE

